

Sug 12/07

Dart Aerospace Ltd.

Date: Wednesday, 11/07/2007 6:30:28 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HOUSING WELDMENT
Job Number	: 32219	Part Number	: D2207041
Estimate Number	: 11874	Drawing Number	: D2207 REV C
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 11/07/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Revision	: C
First Issue	: 03/05/2007	Type	: LARGE FAB ASSY
Previous Run	:	Material	: N/A
Written By	:	Due Date	: 10/05/2007
Checked & Approved By	:	Qty:	5
Comment	: Est. C 01.10.18 Added Step 10 and 11 SM	Um:	Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2208	End Cap	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)	
		End Cap	
		Pick:	
		Qty Part Number Description Batch	
		2 D2208 End cap 33239	
2.0	D22071	Housing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)	
		Housing	
		Pick:	
		Qty Part Number Description Batch	
		1 D2207-1 Housing 33240	
3.0	LARGE FAB 1	Rod LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		Weld as per Dwg D2207	
		Grind welds flush as per Dwg D2207	
4.0	QC9	VISUAL WELDING INSPECTION	
		Comment: VISUAL WELDING INSPECTION	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/07/2007 6:30:28 AM  
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Drawing Name: HOUSING WELDMENT

Job Number: 32219

Part Number: D2207041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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PTC

Comment: LARGE FABRICATION RESOURCE 1

Drill holes using DT8557 as per Dwg D2207

FF 07-07-12 5

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FD

07/07/12 (5)

7.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR

07-07-12

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S8 07/07/12 (5)

9.0	ALS71032130	Insert
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Insert

Qty	Part Number	Description	Batch
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4	DAK57-1032-130	Insert	M6087
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SN 07/07/12 (5)

10.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Install AK57-1032-130 as per Dwg D2207

FF 07-07-12 5

11.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 07/07/12 (5)

12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

11/11/12 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
04/07/12	S.O 5-1	Add QC5 after drilling. Perm.Change		07/07/12		07/07/12	07/07/12

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  DQA:  Date: 07/07/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 32219

Part Number: D2207041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE



(5)  
~~11/07/07~~

Job Completion



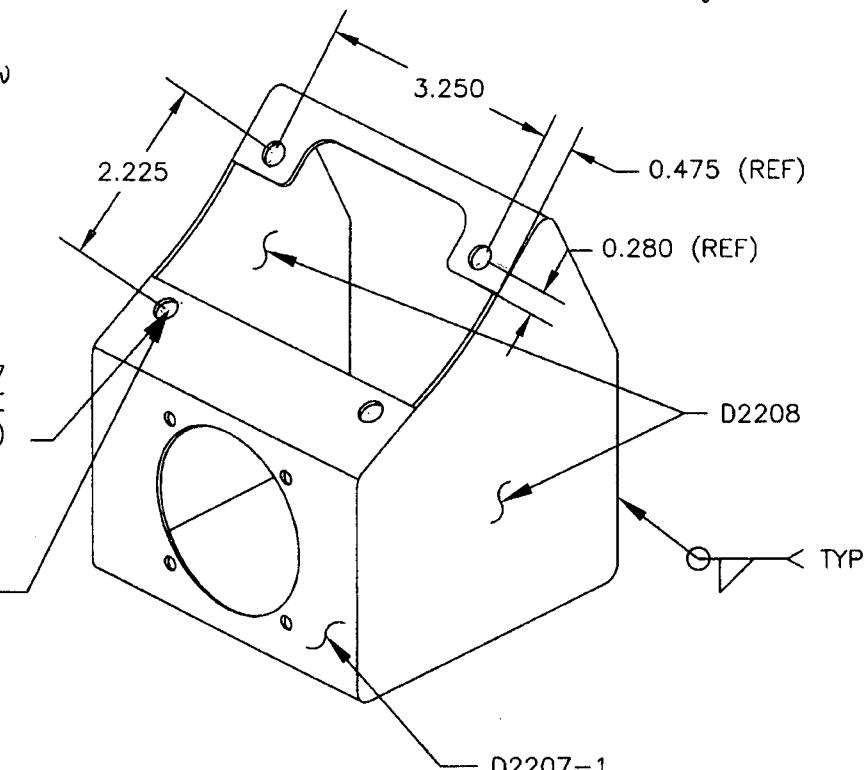
6 87-87-12

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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2207	REV. B SHEET 1 OF 2
DATE 01.02.23		TITLE HOUSING	SCALE 1:2
A	94.09.01	NEW ISSUE	
B	01.02.23	REDRAWN	

**RELEASED**  
01.02.27 *[Signature]***UNDER REVIEW**07.02.09 *[Signature]*

Corrections to FLAT PATTERN

DRILL Ø0.297  
PER DT8557 TEMPLATE  
(4-PLACES)INSTALL  
AKS7-1032-130 OR  
ALS7-1032-130 OR  
AKS4-1032-130 OR  
ALS4-1032-130  
AFTER FINISHD2207-041 ASSEMBLYNOTE:

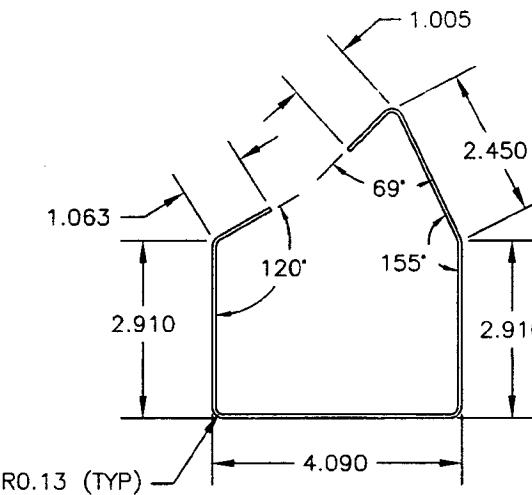
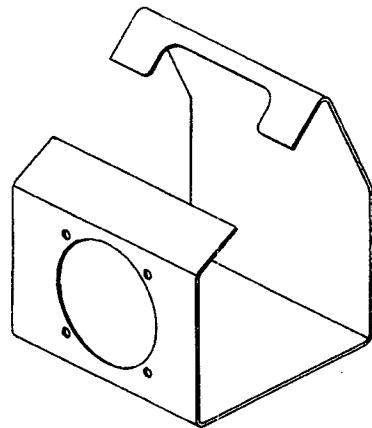
- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT CLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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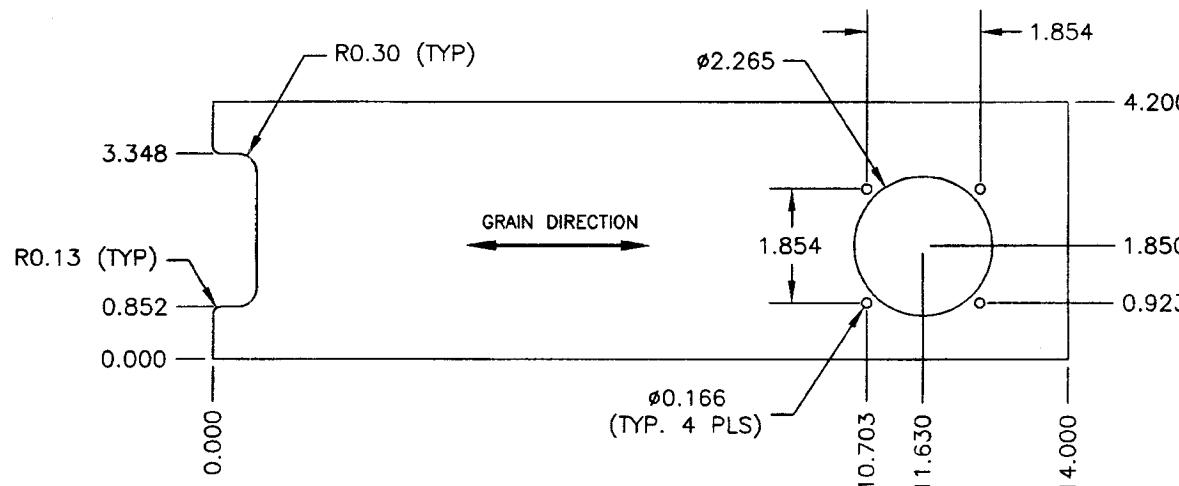
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
DATE 01.02.23	DRAWING NO. D2207	REV. B	SHEET 2 OF 2
TITLE HOUSING	SCALE 1:3		

**RELEASED**  
d.02.27 #**UNDER REVIEW**G7.07 OR 4  
Correction to Part Drawing

D2207-1 BENDING DETAIL



D2207-1 FLAT PATTERN

MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) ALUMINUM 0.063 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED